

Date: Friday, 29/05/2009 3:47:14 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services			<b>Drawing Name</b>	: BASKET LID ASSEMBLY		
<b>Job Number</b>	: 48299B			<b>Part Number</b>	: D2989043		
<b>Estimate Number</b>	: 10207			<b>Drawing Number</b>	: D2989 REV'D		
<b>P.O. Number</b>	:			<b>Project Number</b>	: N/A		
<b>This Issue</b>	: 29/05/2009	<b>S.O. No.</b>	:	<b>Drawing Revision</b>	: D		
<b>Prsht Rev.</b>	: NC			<b>Material</b>	:		
<b>First Issue</b>	: 29/05/2009	<b>Type</b>	: LARGE FAB ASSY	<b>Due Date</b>	: 08/06/2009	<b>Qty:</b>	1
<b>Previous Run</b>	: 48298B			<b>Um:</b>	Each		
<b>Written By</b>	:						
<b>Checked &amp; Approved By</b>	: <u>JUL 09.05.29</u>						
<b>Comment</b>	: Est Rev:I Removed D2989-041 05-11-03 JLM Est Rev:J 08-08-29 revC as per dwg DD verified by:EC Est Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC Est Rev:L 08-12-02 revD as per dwg DD verified by:EC						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
✓ 1.0	D29893	Rib	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Rib batch: <u>B44770</u>	
✓ 2.0	D29894	Rib	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Rib batch: <u>B44769</u>	
✓ 3.0	D29895	Rib	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Rib batch: <u>B44768 -&gt; 1 B45606 -&gt; 1</u>	
✓ 4.0	D22211	Rib	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Rib batch: <u>B418101</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BASKET LID ASSEMBLY

Job Number: 48299B

Part Number: D2989043

Job Number:



Seq. #: Machine Or Operation:

Description :

✓ 5.0 D31821

Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Hinge

batch: B45504

PD 09.06.08

✓ 6.0 D34423

Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Shim

batch: B45607

PD 09.06.08

✓ 7.0 D3827041

Rib Assembly (Inboard)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rib Assembly (Inboard)

batch: B48100

PD 09.06.08

✓ 8.0 D38325

Mesh (Lid)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Mesh (Lid)

batch: B44766

PD 09.06.08

✓ 9.0 D38335

Mesh (Lid End)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mesh (Lid End)

batch: 46307 46767 B44767

SL 09/06/10

✓ 10.0 D3838041

Rib Assembly (Basket Lid, LH)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rib Assembly (Basket Lid, LH)

batch: B44772

PD 09.06.08

✓ 11.0 D3838042

Rib Assembly (Basket Lid, RH)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rib Assembly (Basket Lid, RH)

batch: B44773

PD 09.06.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BASKET LID ASSEMBLY

Job Number: 48299B

Part Number: D2989043

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

- 1- assemble all ribs in DT9446 jig, weld as per dwg D2989
- 2- tack weld mesh on basket as per dwg D2989 using DT9446 jig
- 3- to locate hinges and shims use D2989-041, weld as per dwg D2989

A/R ER316 S.S. Rod Batch: M108160

PD 09-06-08 / SL 09/06/10 /

13.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-06-11

14.0 QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

PD 09-06-11 (C)

15.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

- 1- Plug holes prior to powder coating

PRESS WASH BR 09-06-11 (P)

- 2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

1ST COAT

START TIME: 3:15 pm

OVEN TEMPERATURE: 400°F

FINISH TIME: 3:45 pm

\*\*\*\*\* 2nd coat if necessary \*\*\*\*\*

2ND COAT:

START TIME: 7:00 am

OVEN TEMPERATURE: 400°F

FINISH TIME: 7:30 am

SL 09-06-12 (X1)

16.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat

PD 09/06/15 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

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Drawing Name: BASKET LID ASSEMBLY

Job Number: 48299B

Part Number: D2989043

Job Number:



Seq. #: Machine Or Operation:

Description :

17.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/18 KJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF  
09-06-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21	1		D3838-041	RIB ASSY (BASKET LID, LH)
22	1		D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

RELEASED  
*(08/11/08)*

**NOTES:**

A 1) MATERIAL: N/A  
 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4  
 SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs  
 8) WELD PER DART QSI 004

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**DART AEROSPACE LTD**

**HAWKESBURY, ONTARIO, CANADA**

**DRAWN**

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**APPROVED**

**DE APPR.**

**DATE**

**DRAWING NO.**

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**SHEET 1 OF 5**

**TITLE**

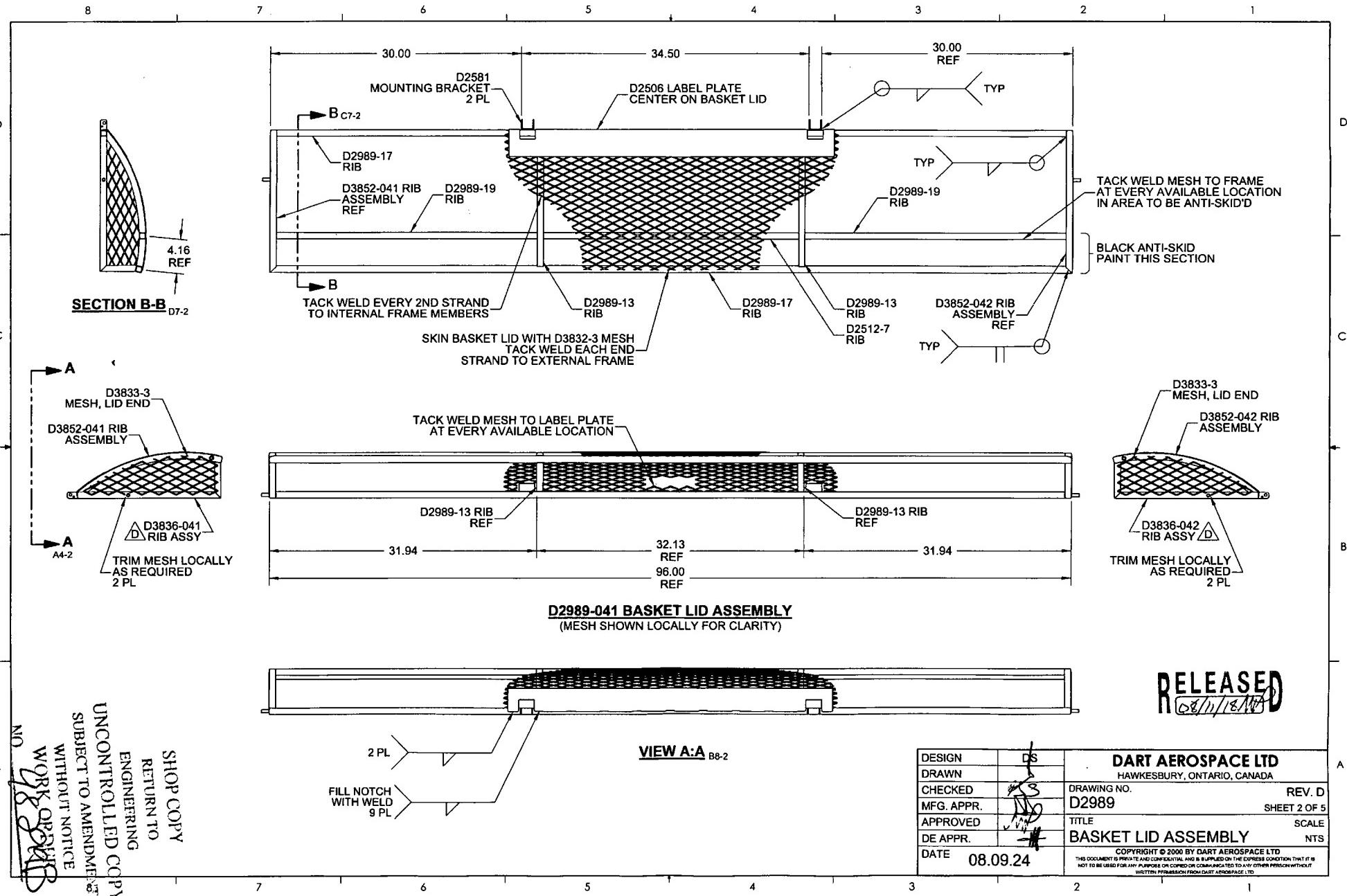
**SCALE**

**NTS**

**BASKET LID ASSEMBLY**

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